

Work Order ID 72864

Wednesday, August 17, 2011 6:36:39 AM



Blue

Page 1

Item ID: D2651-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug

Start Date: 8/17/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 8/24/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-08-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2651	Rev B								
100	Hardinge CNC LATHE SMALL	0.00							
	Hardinge	Memo							
	Hardinge CNC Lathe Small	1- Turn as per Folio FA219 and Dwg D2651-2- Deburr							
		SA 11/8/17							
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo							
	Quality Control								
		SA 11/8/17							
120	QC8- Inspect parts - second check	0.00							
	QC	Memo							
	Quality Control								
		SA 11.8.17							

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

25X 10 M 11/08/17

150



Powdercoat

Powder Coating

Spray paint

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

(Only larger section necessary) START TIME:

TIME: ☐ OVEN TEMPERATURE: _____

☐ FINISH

Blue.

Prim B 117319

Spray paint de fleet Blue B 118395

Clear De 1 fleet B 118093

12.01.24

160



QC

Quality Control

QC 4

QC3- Inspect Part Finish

0.00

Memo

0.00

25 12.01.25

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>FP-21</u>	0.00							
Packaging	Memo	0.00				X25	0	24	12/1/12
Packaging						COUNTED			
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

12/1/30

ME
12-01-26
inv. adj.

Picklist Print

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Page 1

Work Order ID: 72864

Parent Item: D2651-1

Parent Item Name: Plug



Start Date: 8/17/2011

Required Date: 8/24/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: A ☐ 02.04.15 ☐ New Issue ☐ NG ☐
IPP: B ☐ 05.12.12 ☐ added deburr EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.500

Purchased

No

100

f

65.2220

0.0401

0.844211



1058117

6061-T6 Round Bar .500"

Location

Loc Qty

Loc Code

MAT012

65.222

114488

4.322

117379

60.9

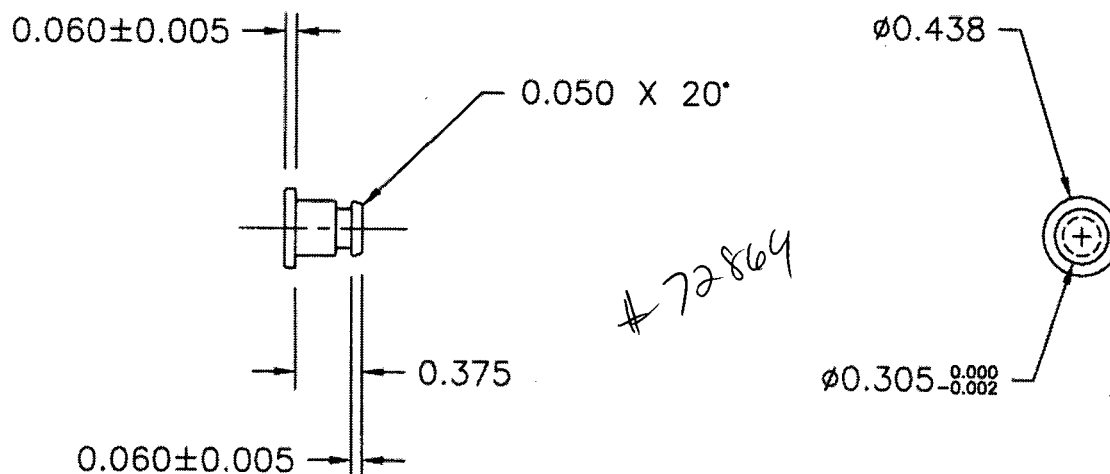
1.2817



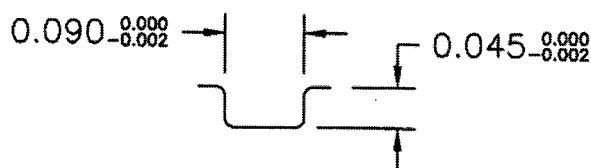
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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